

Work Order ID 60956

July 29, 2010 10:38:20 AM



Page 1

Item ID: D2580-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 205 Skidtube bent detail

Start Date: 7/29/10 Start Qty: 2.00



Cust Item ID:

Required Date: 8/05/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *M*

Date: *10-7-29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Inspect mat'l D2500-1-190 for damage.

2- Chemical Conversion Coat as per QSI 005 4.1

NDP 10-8-3

101

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

AM 10-08-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60956

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Drill pilot holes using drill jig DT 8149 (Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580 without cutting fluid

3-Deburr and blow out all chips from inside of tube

4-Bond web in place per QSI 015.

□□

A/R Sikaflex-291 batch: M115114 □□□

Sikaflex expire date: 01/20/11

Start time and date: 10:00am bond for 12hrs

10-08-09

an 10-08-04 (2)

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

[Handwritten signature]

10-8-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 60956

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Page 3

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Start Date: 7/29/10 Start Qty: 2.00

Cust Item ID:

Required Date: 8/05/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: 46

0.00

DP

10-8-10

②



Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/10

ME

10-8-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60956



Parent Item: D2580-1



Parent Item Name: 205 Skidtube bent detail

Start Date: 7/29/10

Required Date: 8/05/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B 01.11.08 Revised Step 9, 10, 12, and 13 SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-190 Ext'n -I Beam Tube 4"		Manufactured	No				Each	108.0000	1	2			

Location

LG

52319
58427

Loc Qty

108
31
77

Loc Code

DP 10-8-3

D2596



Web, 205 Skidtube

Manufactured No

110 Each

2.0000 1 2

Location

LG46

60855

Loc Qty

2
2

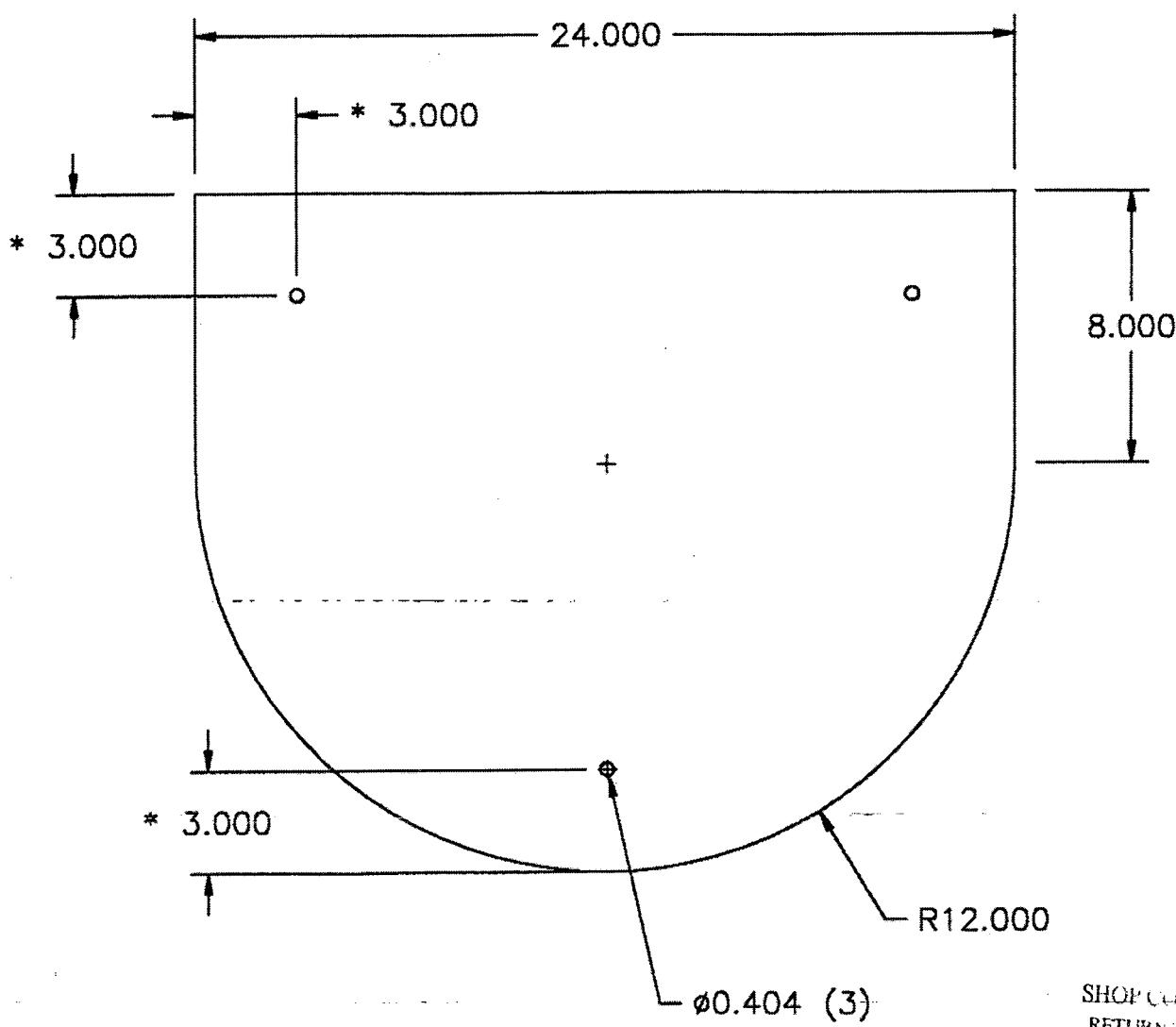
Loc Code

DP 10-8-4



DESIGN B WILLIAMS	DRAWN BY K HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bue</i>	APPROVED <i>BW</i>	DRAWING NO. D2511	REV. A SHEET 1 OF 1
DATE 95.11.29		TITLE LINER (END)	SCALE 1:5

* DRILL HOLES TO FIT DURING INSTALLATION



SHOP CO
RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO
WITHIN
WORK

NO: 40954

MATERIAL: UHMW POLYMER, 0.125 THICK WHITE

10-729

W/O:			WORK ORDER CHANGES					
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